Work Order ID 118945

May-06-14 8:07:43 AM

118945

Item ID: D4324-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Armrest Assembly

Start Date: 5/05/14 **Start Qty:** ~~5.00~~ 4 *5*

Required Date: 5/05/14 **Req'd Qty:** 5.00 *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-05-07 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr** ✓								
D4324	B								
110		0.00							
110						4	RF		OCT 2 9 2014
Small Fab	**Memo**	0.00							
Small Fab	ASSEMBLE PART SHOWN AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
120						4			
QC	**Memo**	0.00							OCT 2 9 2014
Quality Control									
130	Pick Kit	0.00							
130						4			OCT 3 0 2014
Packaging	**Memo**	0.00							
Packaging	PICK AND BAG HARDWARE AS PER DWG AND NOTE 9.								

N387

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4324-011 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Armrest Assembly

Start Date: 5/05/14 **Start Qty:** 5.00 *5* **Cust Item ID:**
Required Date: 5/05/14 **Req'd Qty:** 5.00 *5* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC4- 100% Inspect kits for completeness	0.00							
140					DAS 31 9-89	4		14-10-30	
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 382	0.00							
150						4			DAS 08 9-89
Packaging	**Memo**	0.00						OCT 30 2014	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160								14/10/30	
QC	**Memo**	0.00							
Quality Control									

14-1030

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
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General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
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☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

May-06-14 8:07:42 AM

Work Order ID: 118945 *118945*

Parent Item: D4324-011 *D4324-011*

Parent Item Name: Armrest Assembly

Start Date: 5/05/14 **Required Date:** 5/05/14

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP Rev:A 14.04.24 NEW ISSUE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-041		Manufactured	No			110	Each	0.0000	1	5			
D4324-041 Armrest Weldment				123632 118864					**	2 2	FF	OCT 2 9 2014	
D4324-043		Manufactured	No			110	Each	4.0000	1	5			
D4324-043 Arm Support Assembly				117686					**	4	FF	OCT 2 9 2014	
				Location		**Loc Qty**		**Loc Code**					
				ST103		4							
					116640	4							
D4324-045		Manufactured	No			110	Each	3.0000	1	5			
D4324-045 Cushion Assembly									**		FF	OCT 2 9 2014	
				Location		**Loc Qty**		**Loc Code**					
				ST191		3		B119006		4			
					117560	3							
AN3-4A		Purchased	No			130	Each	302.0000	3	15			
AN3-4A Bolt									**				
				Location		**Loc Qty**		**Loc Code**					
				ST350		254							
					m128429	100							
					m128739	154							
				ST511		48							
					m127044	48				15		14-10-30	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Pressure/Forced
☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID: 118945 *118945*
Parent Item: D4324-011 *D4324-011*
Parent Item Name: Armrest Assembly

Start Date: 5/05/14 **Required Date:** 5/05/14
Start Qty: 5.00 **Required Qty:** 5.00

AN3-12A		Purchased	No		130	Each	77.0000	1	5	DAS 06 9-89
AN3-12A								**	M130506	
Bolt										

Location	Loc Qty	Loc Code	
ST351	75		
m128398	38		
m128687	37		
ST511	2		
m125709	2		

DAS 31 9-89

MS21075L3	MS21075L3N	Purchased	No		130	Each	8.0000	3	15	DAS 06 9-89
MS21075L3								**	M130281X4	
Nut Plate										

DAS 31 9-89

Location	Loc Qty	Loc Code	
ST318	8		
116398	8		

MS51861-45C		Purchased	No		110	Each	76.0000	4	20	OCT 2 9 2014
MS51861-45C								**	FF	
Screw										

Location	Loc Qty	Loc Code	
ST290	76		
m128993	76		16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Other

Picklist Print

May-06-14 8:07:42 AM

Work Order ID: 118945 *118945*

Parent Item: D4324-011 *D4324-011*

Parent Item Name: Armrest Assembly

Start Date: 5/05/14 **Required Date:** 5/05/14

Start Qty: 5.00 **Required Qty:** 5.00

NAS1149F0332P	Purchased	No		130	Each	5,824.000	3	15

NAS1149F0332P **

Washer

DAS 9-89

Location	Loc Qty	Loc Code	
GA	205		
122063	205		
ST295	2546		
123900	12		
m123185	34		
m128401	2500		
ST510a	3055		
125646	555		
m127831	2500		15
ST522	18		
m123185	18		

DAS 9-89

NAS1149F0363P	Purchased	No		130	Each	747.0000	1	5

NAS1149F0363P **

WASHER

DAS 31 9-89

Location	Loc Qty	Loc Code	
ST510a	747		
124555	600		
125445	147		5

DAS 31 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

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Work Order: _____

Part No. _____

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DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Other

